

Work Order ID 154222

Tuesday, December 06, 2016 2:50:50 PM

154222

Page 1

Item ID: D3886-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lug Assembly
Start Date: 12/9/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 12/14/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: DEC 07 2016 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3886	B							DAS 46 9-89	10/12/11

100

0.03

100

Waterjet

FLOW CNC Waterjet

Memo

FLOW WATER JET
1-Cut as per Dwg D3886-3
Dwg Rev: B
Prog Rev: B

2-Deburr if necessary

0.05

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.01

DAS
46
9-89

10/12/11

Tuesday, December 06, 2016 2:50:50 PM

Page 2

[illegible]

Tuesday, December 06, 2016 2:50:50 PM

Item ID: D3886-041

Accept

N9000401 00

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lug Assembly

Start Date: 12/9/2016 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 12/14/2016 **Req'd Qty:** 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject Qty

Reject
Number

**Insp.
Stamp**

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.07

Quality Control

JAN 31 2017

Picklist Print

Tuesday, December 06, 2016 2:50:50 PM

Page 1

Work Order ID: 154222

154222

Parent Item: D3886-041

D3886-041

Parent Item Name: Lug Assembly

Start Date: 12/9/2016

Required Date: 12/14/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA		Purchased	No			100	sf	20.7030	0.1472	0.5888			
M304S12GA									**				
304/316 0.100" Sheet													

Location

Loc Qty

Loc Code

MAT019

20.703

m131322

4.723

m135344

15.98

D3886-1

Manufactured

No

150

Each

16.0000

1

4

D3886-1

Lug

Location

Loc Qty

Loc Code

WA002

16

142654

1

153030

15

DAS
46
9-89

16/12/11

17-01-20
JBL

0.6

13

DQA: _____ Date: _____



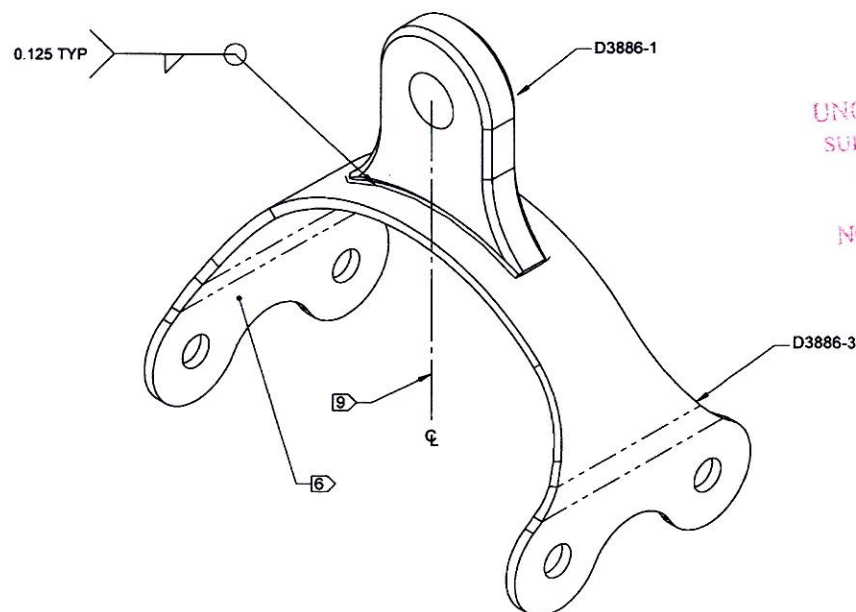
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

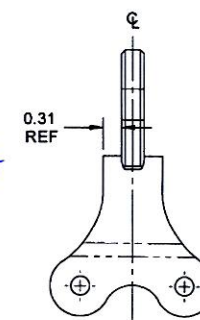
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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				QC / QA Coordinator Approval																																																																
Root Cause		FAULT CATEGORY																																																																		
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OTHER : _____																																																																				

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3886-041	LUG ASSEMBLY
2	1	D3886-1	LUG
3	1	D3886-3	BRACKET



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154222
MCS
16-12-07



D3886-041 LUG ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3886-041" AND BATCH NUMBER USING FINE POINT PERMANENT INK MARKER ON UNDERSIDE OF PART
 - 7) WEIGHT: 0.53 lbs
 - 8) WELD PER DART QSI 004
 - 9) BOTH PARTS CENTER SHOULD BE IN LINE WITH THE ϕ

RELEASED
2/6/15 MB

B	RE-DESIGN D3886-1 (ZN B4-2); RE-DESIGN D3886-3 (ZN A4-3); REVISED D3886-3F (ZN B4-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.30		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D3886** REV. B
SHEET 1 OF 4

TITLE **LUG ASSEMBLY** SCALE NTS

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NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

8 7 6 5 4 3 2 1

D

C

B

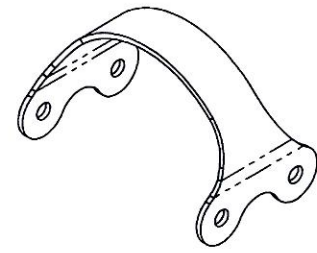
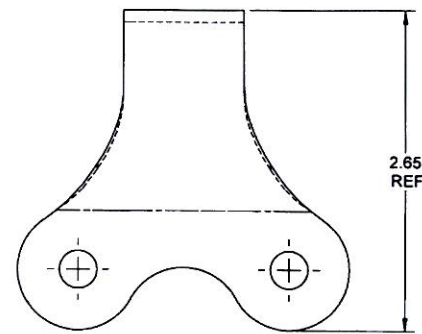
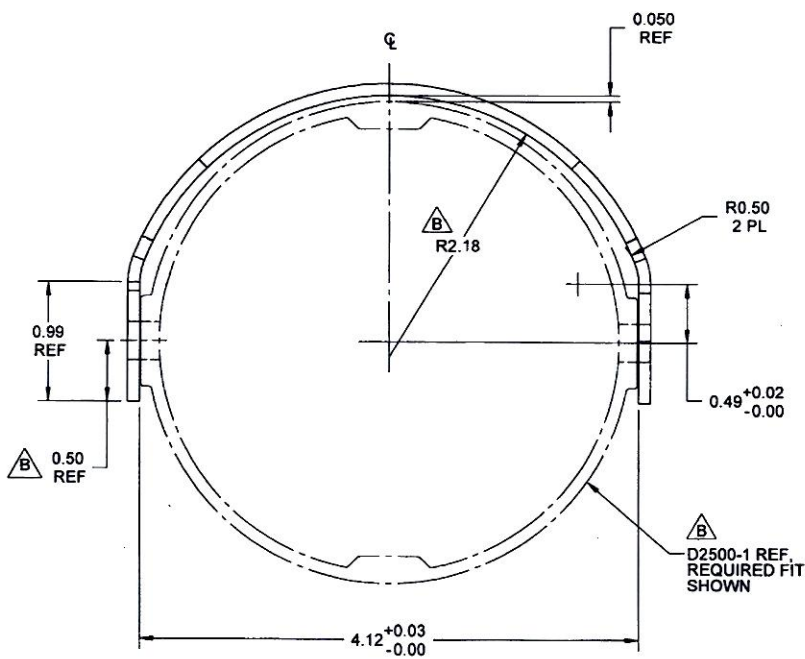
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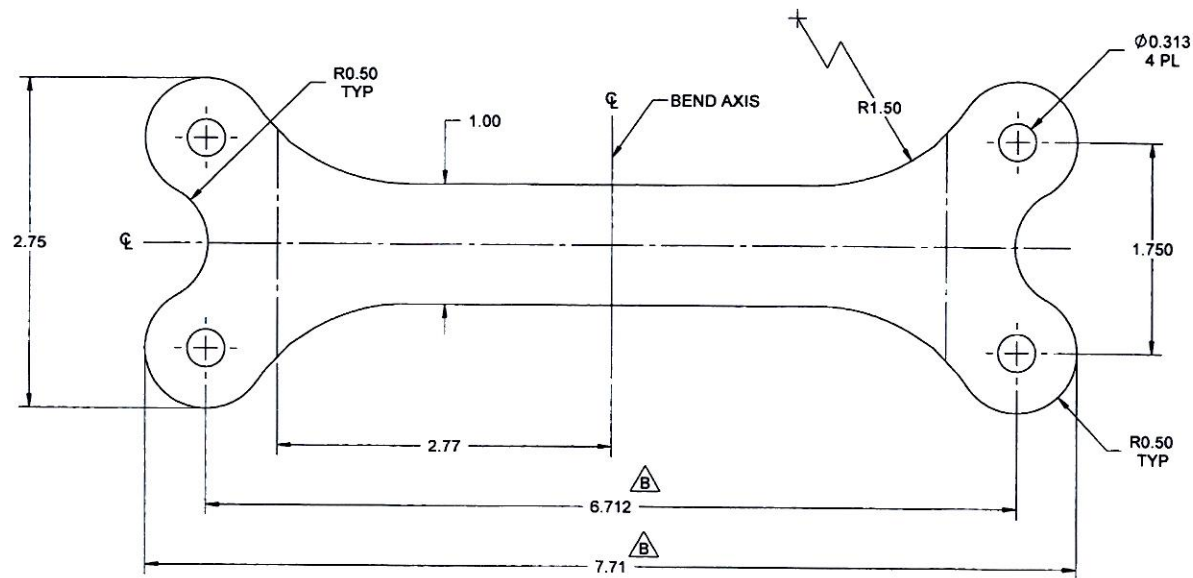


D3886-3 BRACKET
(MAKE FROM D3886-3F)

RELEASED
28/07/15/17

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3886	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D3886-3F FLAT PATTERN $\triangle B$

RELEASED
9/27/15

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 12 GAUGE (0.100) THICK, (REF. DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3886	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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